

Work Order ID 61660

Tuesday, August 31, 2010 10:27:59 AM



Page 1

Item ID: D3935-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Pylon Protector

Start Date: 8/31/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: ✓Date: 10-8-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3935

B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3935

Dwg Rev: BProg Rev: B

2- Deburr if necessary

0.00

B 10-9-7

②

EP 10/09/06 ②

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 10-9-7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries




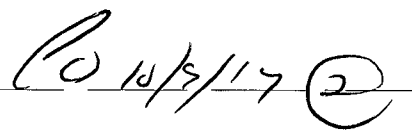

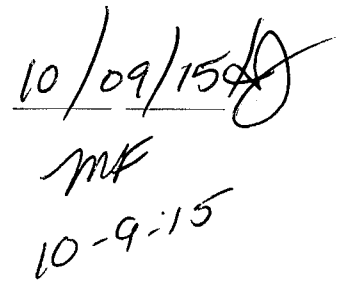
Work Order ID 61660

Tuesday, August 31, 2010 10:27:59 AM

Page 2

Item ID: D3935-2 Accept  Setup Start 
Revision ID: Stop 
Item Name: Pylon Protector
Start Date: 8/31/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 9/7/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|---|
| 120  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | | | |  |
| 130  Packaging Packaging | Identify as per dwg & Stock Location Memo | 0.00 0.00 | | | | | | |  |
| 140  QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | |  |

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 31, 2010 10:28:03 AM

Page 1

Work Order ID: 61660



Parent Item: D3935-2



Parent Item Name: Pylon Protector


Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 2.00

Required Qty: 2.00

Comments:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MLEXS.125-F60029-04  GE PLASTICS LEXAN SHEET | | Purchased | No | | | 100 | sf | 2,704.423 | 8.69 | 18,294.74 | | | |



1810-9-2

Location

Loc Qty

Loc Code

MAT

2704.4238

114032

467.9238

115261

2236.5

114032

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 6660 |
| Description: Pylon Wall Protector, RH | | Part Number: | D3935-2 |
| Inspection Dwg: D3935 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 3.50 | +/-0.030 | 3.50 | ✓ | | T B01 | |
| 9.00 | +/-0.030 | 9.00 | ✓ | | T | |
| 14.70 | +/-0.030 | 14.70 | ✓ | | T | |
| 16.20 | +/-0.030 | 16.20 | ✓ | | T | |
| 33.40 | +/-0.030 | 33.375 | ✓ | | T | |
| 34.25 | +/-0.030 | 34.25 | ✓ | | T | |
| 34.60 | +/-0.030 | 34.60 | ✓ | | T | |
| 34.72 | +/-0.030 | 34.72 | ✓ | | T | |
| 22.85 | +/-0.030 | 22.85 | ✓ | | T | |
| 19.15 | +/-0.030 | 19.15 | ✓ | | T | |
| 35.39 | +/-0.030 | 35.39 | ✓ | | T | |
| 8.05 | +/-0.030 | 8.05 | ✓ | | T | |
| 15.05 | +/-0.030 | 15.05 | ✓ | | T | |
| 19.00 | +/-0.030 | 19.00 | ✓ | | T | |
| 19.25 | +/-0.030 | 19.25 | ✓ | | T | |
| 20.25 | +/-0.030 | 20.25 | ✓ | | T | |
| 23.25 | +/-0.030 | 23.25 | ✓ | | T | |
| 24.35 | +/-0.030 | 24.35 | ✓ | | T | |
| 29.25 | +/-0.030 | 29.25 | ✓ | | T | |
| 32.75 | +/-0.030 | 32.75 | ✓ | | T | |
| 0125 | +/-0.010 | .131 | ✓ | | V B02 | |
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| Measured by: | B | Audited by: | S | Preliminary Approval: | N/A |
| Date: | 10-9-2 | Date: | 10/09/07 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------|------------|----------|
| A | 09.06.22 | New Issue | KJ | |
| B | 10.08.18 | Dwg Rev updated | KJ | |

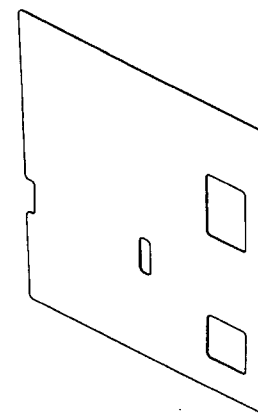
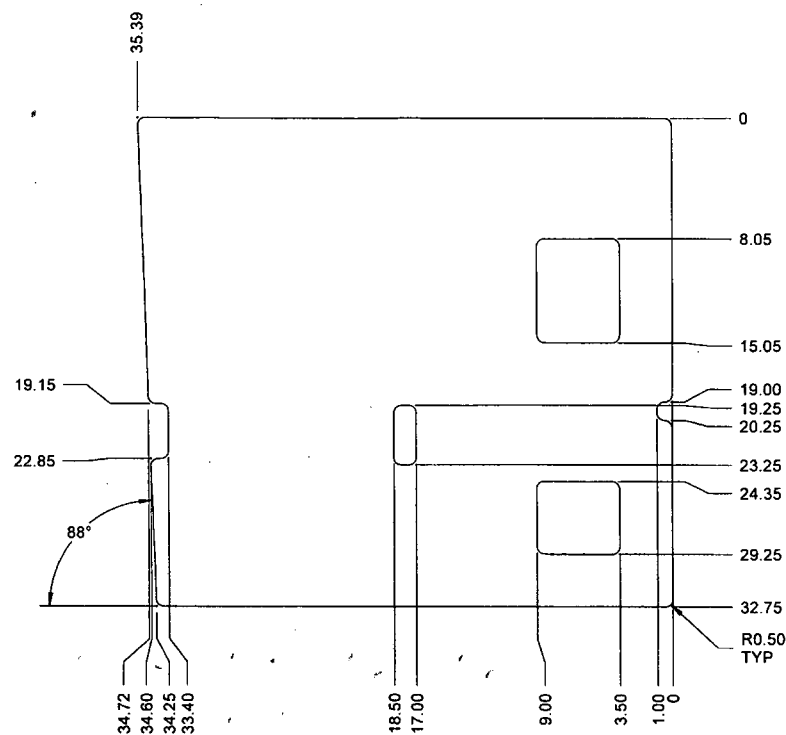
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *61460*
BS10-8-31

RELEASED
2009-10-22
MD

D3935-1 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8922

| B | ADD -3, -4 (SHEET 3, 4) | <i>HS</i> | 09.08.19 |
|------------|-------------------------|-----------|----------|
| A | NEW ISSUE | HS | 09.04.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>PH</i> | | |
| DRAWN | <i>PH</i> | | |
| CHECKED | <i>PH</i> | | |
| MFG. APPR. | <i>PH</i> | | |
| APPROVED | <i>PH</i> | | |
| DE APPR. | <i>PH</i> | | |
| DATE | 09.08.19 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3935** REV. B
SHEET 1 OF 4

TITLE **PYLON PROTECTOR** SCALE NTS

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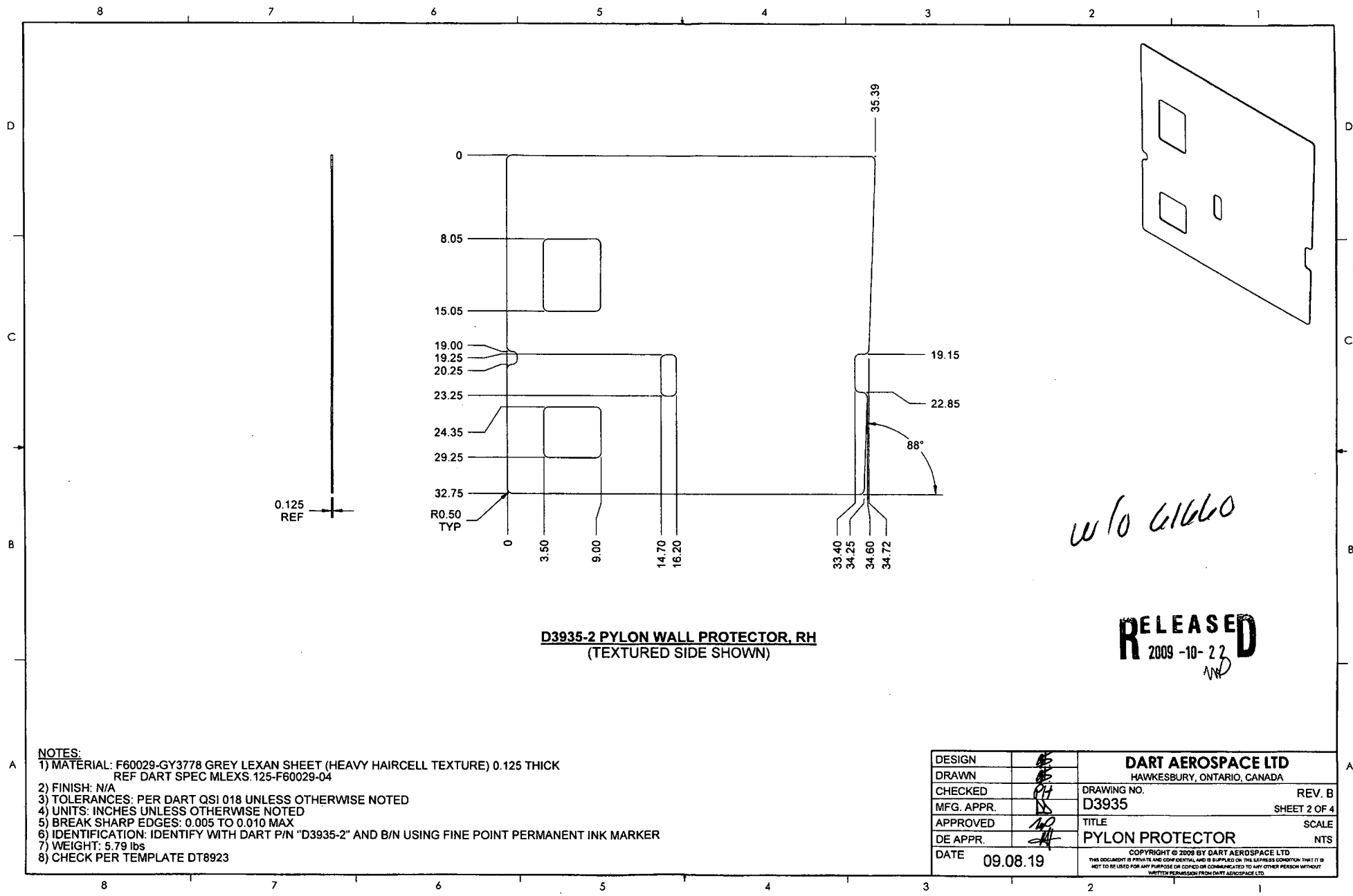
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries



WFO 61660

D3935-2 PYLON WALL PROTECTOR, RH
(TEXTURED SIDE SHOWN)

RELEASED
2009-10-22
WFO

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS. 125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-2" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8923

| | | | |
|------------|----------|--|--------------|
| DESIGN | AS | DART AEROSPACE LTD | |
| DRAWN | AS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. B |
| MFG. APPR. | DS | D3935 | SHEET 2 OF 4 |
| APPROVED | WFO | TITLE | SCALE |
| DE APPR. | WFO | PYLON PROTECTOR | NTS |
| DATE | 09.08.19 | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

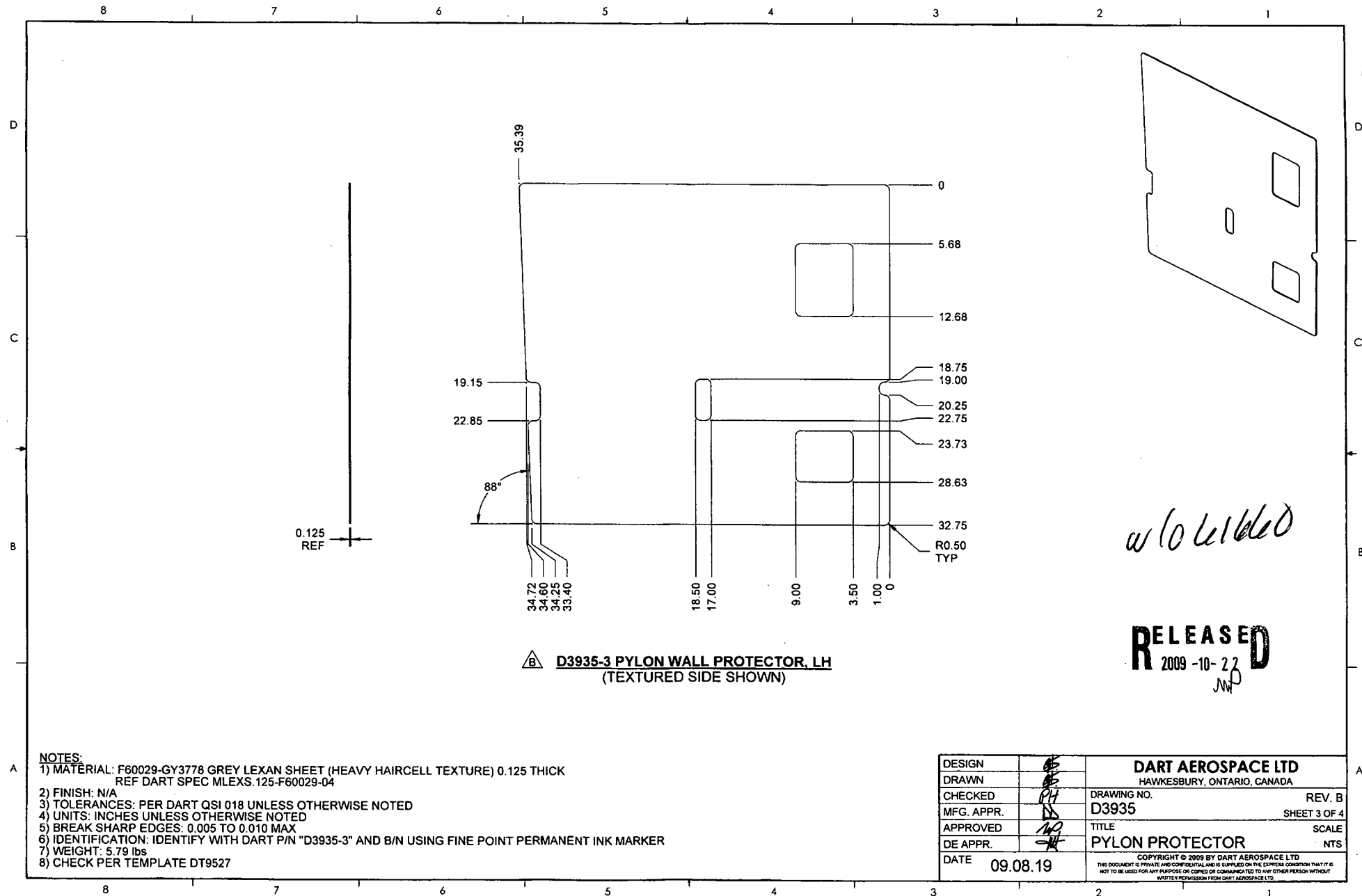
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NOTE: Date & initial all entries



RELEASED
2009-10-22
JW

| W/O: | | WORK ORDER CHANGES | | | | | |
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